

Work Order ID 73591 - |
 Tuesday, September 06, 2011 11:12:38 AM



Page 1

Item ID: D3436-043

Accept



Setup

Start



Revision ID:

Stop



Item Name: Step LH

Start Date: 9/6/2011

Split

Start Qty: 2.00



Required Date: 9/9/2011

Req'd Qty: 2.00



Reference:

Cust Item ID:

ASAP

Customer:

Approvals: Process Plan: *MF*

Date: 11-09-06

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3436

Rev A

100



Large Fab

Large Fab

Memo

0.00

0.00

Tool ID

Tool #

Plan

Accept

Reject

Reject

Number

Insp.
Stamp

Set Up/
Run Hours

Code

Qty

Qty

Stamp

100



Large Fab

Large Fab

Memo

0.00

0.00

Q 11-9-8 (x2)

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
 Dwg D3436Dwg Rev: *A* Qty Part Number Description
 Batch A/RN/A 4130 Welding Rod *M100075* Weld
 left step D3436-7 using welding Jig DT

110



BAND SAW

Bandsaw

Memo

0.00

0.00

EL 11-9-8 (x2)

Jeaspa Bandsaw

I- Slit part D3436-041 on bandsaw as per Dwg D3436
 deburr

2-

120



QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Quality Control

-2 Ø 38.1/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73591

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Page 2

Item ID: D3436-043

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Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

8/6/09/08

72

47

140



Powdercoat

Powder Coating

W117745

White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME: 1:00

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:30

Wing Walk batch:

1/83/3 ← →

BL 11-9-12 ②.

2x 8ml 11/09/12

LH

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

241

d

8ml 11/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM



Page 3

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

155



Small Fab

Operation
Description

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/13



170



Packaging

Memo

0.00

Identify as per dwg & Stock Location: 198A

0.00

Packaging

10/13/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM



Page 4

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

n/a/14 JG

MF
9-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 11:12:34 AM

Work Order ID: 73591



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 9/6/2011

Required Date: 9/9/2011

Comments: IPP A 05.05.11 New Issue KJ/JLM

Start Qty: 2.00

Start Qty: 2.00

Required Qty: 2.00

Required Qty: 2,00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 11:12:35 AM

Page 2

Work Order ID: 73591



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 9/6/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-9



Pad

Manufactured No

100

Each

12.0000

2



4
B6/09/13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	8	
56830	2	
69599	6	
ST053	4	
66567	4	

B73669 1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

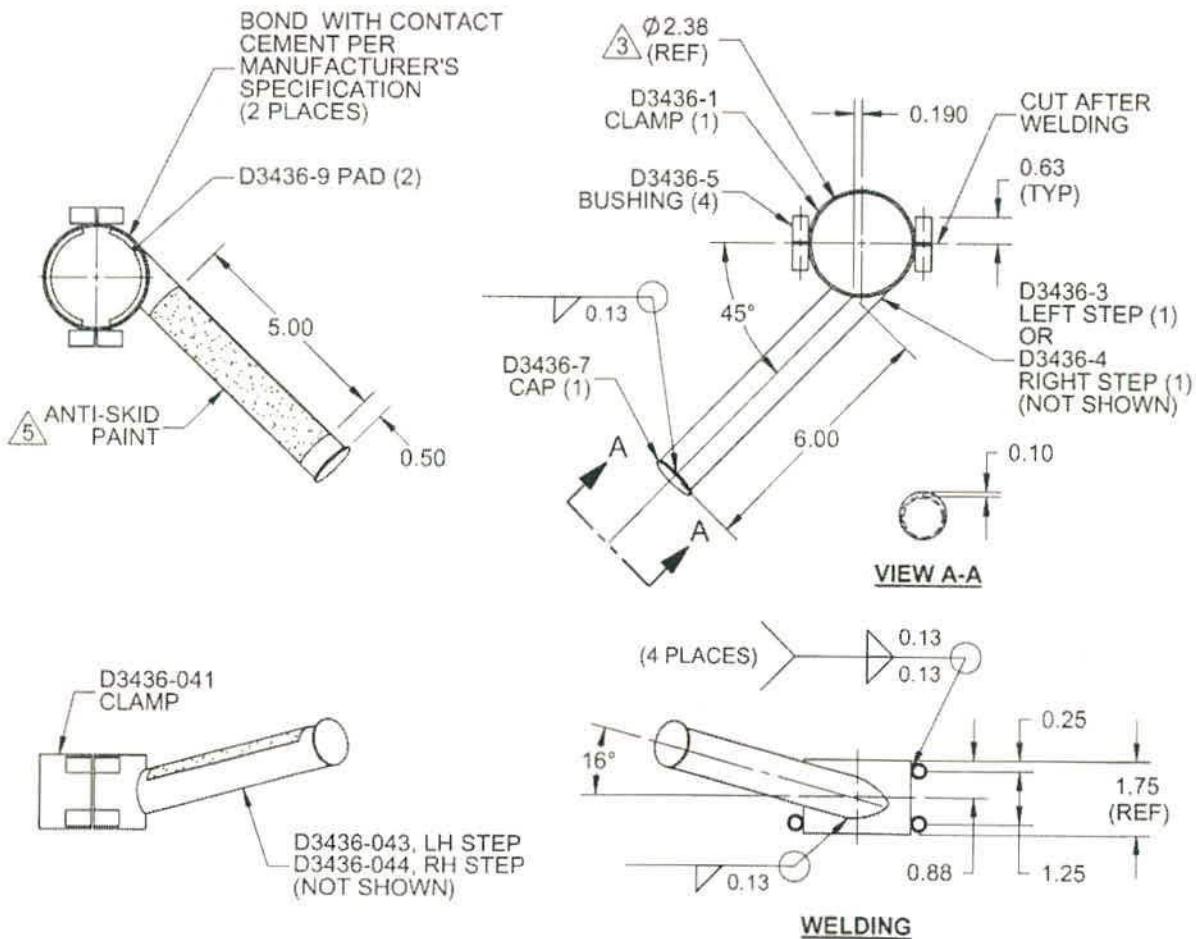
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A	SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4	
A	05.04.28	NEW ISSUE		



NOTES:

1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
 2) WELD PER DART QSI 004
 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D.
 SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING
 OF SKID CROSS TUBE
 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES

4/13591
RELEASED

05.05.27 *MM*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

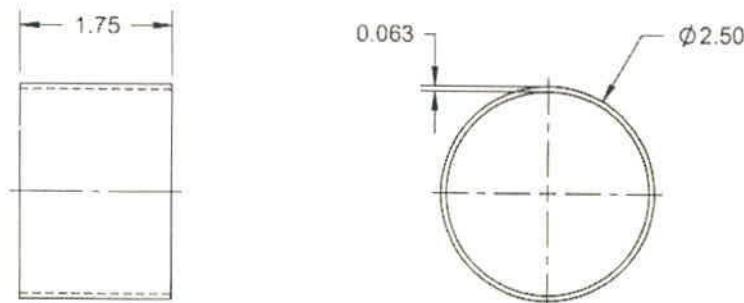
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2	



D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED*05-05-27 MM*

D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

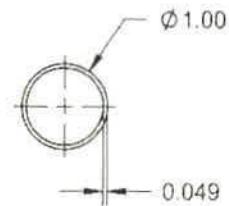
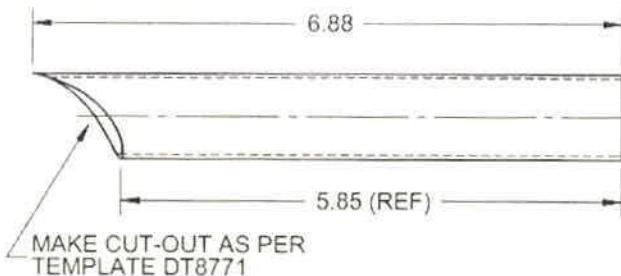
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

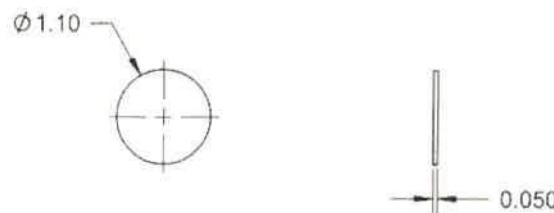
DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436
DATE 05.04.28	TITLE MAINTENANCE STEP	REV. A SHEET 3 OF 4 SCALE 1:2

**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED05-05-27 *MM***D3436-3/ -7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

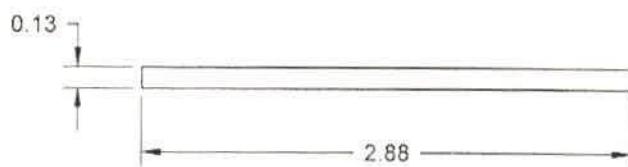
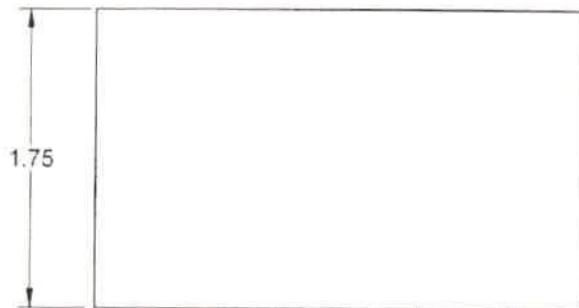
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:1	



RELEASED
05.05.27 *MM*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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